

Work Order ID 76978***76978***

Page 1

Thursday, November 24, 2011 1:37:34 PM

Item ID: D3875-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector

Start Date: 11/24/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: QDate: 11/12/07

Tooling:

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3875	Rev A								

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x1

11/12/07

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QS1022 POLYCARBONATE
Temp: 240°FTime IN: 4:00 pm 11/12/06Time OUT: 2:00

x1

11/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Memo

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Required Date: 12/5/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

140

0.00

HandThermo

Memo

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

0.00

QC

Memo

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

160

0.00

QC

Memo

Quality Control

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76978

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo <i>PMP 76977</i>	0.00							<i>11/24/13</i>
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									<i>11/12/13</i>
QC	Memo	0.00							
Quality Control									<i>MF</i> <i>11-12-13</i>

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Picklist Print

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Page 1

Work Order ID: 76978

76978

Parent Item: D3875-1

D3875-1

Parent Item Name: Floor Protector

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.118-90318-08

Purchased

No

100

sf

1,802.424

9.84

9.84

MI FXS 118-90318-08

Lexan Sheet

**

Location

Loc Qty

Loc Code

therm

1802.424621

1802.42462

113127

9.84 sy ft

11/13/08

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DART AEROSPACE LTD		Work Order:	76978
Description: Floor Protector		Part Number:	D3875-1
Inspection Dwg: D3875	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Wh Date: 11/12/07

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.057"	✓		CAL TH-DT	
0.080	Min	0.085"	✓		CAL TH-DT	
45.2	+/-0.100	45.26"	✓		TAPE DL-01	
21.8	+/-0.100	21.75"	✓		TAPE DL-01	
1.4	+/-0.100	1.438"	✓		Vein DL-02	

Measured by: Wh Date: 11/12/13

Audited by: Switz/13 Date:

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>Wh</u>

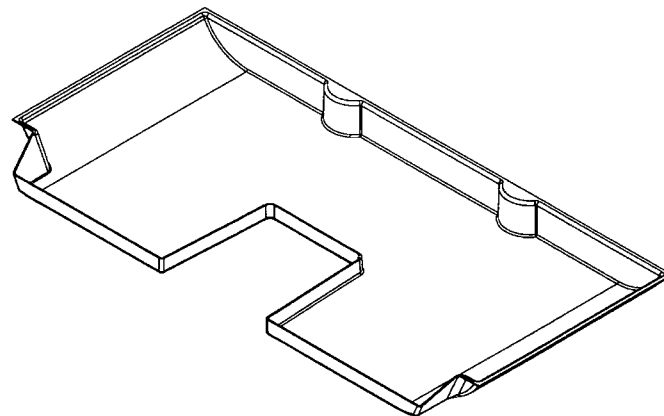
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D3875-1 FLOOR PROTECTOR (206B)

SHOP COPY
 REVISION
 ENGR. 11-24
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 70978

R11-11-24

RELEASED
29/05/05 NP

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A		NEW ISSUE		PH	09.01.29
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AK				
CHECKED	AK			DRAWING NO.	REV. A
MFG. APPR.	TS			D3875	SHEET 1 OF 2
APPROVED	AK			TITLE	SCALE
DE APPR.	AK			FLOOR PROTECTOR (206B)	NTS
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

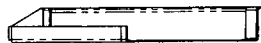
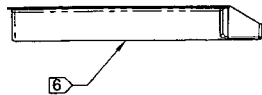
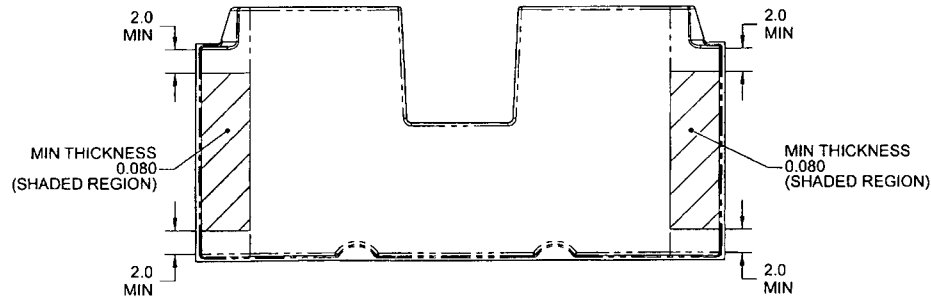
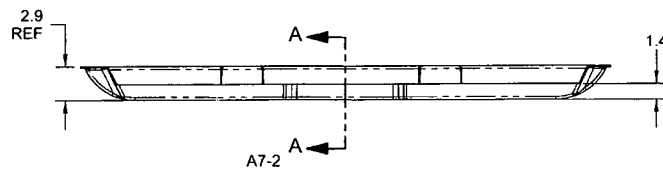
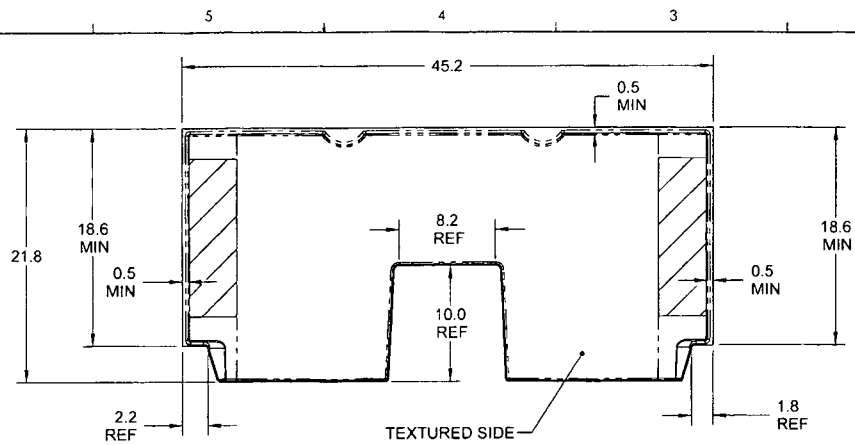
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SECTION A-A B4-2

D3875-1 FLOOR PROTECTOR (206B)

DESIGN	REV	DART AEROSPACE LTD	
DRAWN	REV	HAWKESBURY, ONTARIO, CANADA	
CHECKED	REV	DRAWING NO. D3875	REV. A
MFG. APPR.	REV	TITLE	SHEET 2 OF 2
APPROVED	REV	FLOOR PROTECTOR (206B)	NTS
DE APPR.	REV	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DATE	09.01.29	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
29/05/05

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